

Wednesday, 1/4/2006 2:36:54 PM

Use. Kim Johnston **Process Sheet** : CU-DAR001 Dart Helicopters Services **Drawing Name** : STRUT Customer Job Number : 25391 : 10984 **Estimate Number** :NIA : D2565403 Part Number P.O. Number S.O. No. : NIA : D2565 REV E : 1/4/2006 **Drawing Number** This Issue : NC **Project Number** : N/A Prsht Rev. : NIA : SMALL /MED FAB : E First Issue **Drawing Revision** : NIA Al4: Material **Previous Run Due Date** : 1/20/2006 Qty: 8 Um: Each SEE COMMENT. BELOW Written By Checked & Approved By : Est:A 04.05.10 New Issue KJ/JLM Comment **Additional Product** Job Number: Seq. #: **Machine Or Operation:** Description: M304TR0750W049 304 RD Tube .750 x .049W 1.0 Comment: Qty.: 1.4560°f(s)/Unit Total: 11.6483 f(s) D Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall 06.01.12 (M304TR0750W049) NC BRAKE BRAKE NC 2.0 Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313 SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 3.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill hole open to Ø0.316" as per Dwg D2565 (one end only) Deburr INSPECT WORK TO CURRENT STEP 4.0 QC5 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING 5.0

POWDER COATING



Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3





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## Dart Aerospace Ltd

W/O:		WORK ORDER CHAN	IGES		;						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No:	 PAR #:	Fault Category:	NCR: Yes No DQA	Date: 06/02/1
			QA: N/C Closed:	Date:

NCR:		W	ORK OR	DER NON-CONFORMANC	E (NCR)	•						
		Description of NC	Corrective Action Section B			Verification	Ammerial					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector				
06.01.17	3	I start has a hole punch mark off the side of the	10002	Scrapicles traf	DV		As	2				
		hole, very deep in the motil connot be e polished out.			06/01117	66.01.17		16.01.17				
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NOTE: Date & initial all entries



Wednesday, 1/4/2006 2:36:54 PM User: Kim Johnston **Process Sheet Drawing Name: STRUT** Customer: CU-DAR001 Dart Helicopters Services Job Number: 25391 Part Number: D2565403 Job Number: Seq. #: Description: **Machine Or Operation:** INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 6.0 Comment: INSPECT POWDER COAT PACKAGING RESOURCE #1 7.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:\_ DC 8.0 Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

<b>Dart Aerospace Lt</b>
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W/O:		g (# ) (#)	WORK ORDER	CHANGES				7L	
DATE	STEP		PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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Part No		PAR #:	Fault Category:			No DQ		Date:	

NCR: WORK ORDER NON-CONFORMANCE (NCR)									
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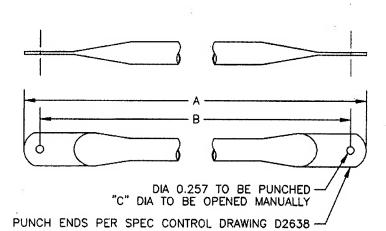
NOTE: Date & initial all entries





DESIG	-#	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHEC	(ED A	APPROVED	DRAWING NO.	REV. E
	#	#	D2565 SHEET	1 OF 1
DATE			TITLE	SCALE
 04.0	5.05		STRUT	1:3
Α		96.05.03	NEW ISSUE	
R		97.03.15	CORRECT D2565-111 DIM A	

04.0	05.05	STRUT 1:3
Α	96.05.03	NEW ISSUE
В	97.03.15	CORRECT D2565-111 DIM. A
С	98.10.05	UPDATED MATERIAL NOTE (TSR A603)
D	02.06.05	ADD -3XX PARTS; ADD FINISH
E	04.05.05	ADD D2565-401-411; RMV ANGLE D



PART #	Α	В	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	0.516
D2565-109	12.31	11.51	_
D2565-111		12.85	<u> </u>
02303-111	13.03	12.00	
D2565-201	22.79	22.00	0.716
D2565-203	20.75	22.00	
		19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	
D2565-209			
D2565-211	14.14	13.34	
	-1-		
D2565-301		26.23	
D2565-303	25.34	24.54	0.316
D2565-305		22.93	0.316
D2565-307	20.86	20.06	****
D2565-309		19.37	_
D2565-311	16.30	15.50	_
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	_
D2565-411	13.81	13.01	_

## **GENERAL NOTES**

1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL (REF DART SPEC. M304TR0.750W0.049)

ENSURE SEAMLESS TUBE IS USED

2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

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